

ABSTRACT

Blue oil bottle cap for AHM is one of products that is produced continuously for fulfill request from PT LA . Based on the historical data from January-October 2016, there are late delivery happens to PT LA. Because of that, the researcher should do further research about production process of blue oil bottle cap for AHM using lean manufacturing approach.

First step is making a value stream mapping current state and process activity mapping current state. That should be done to know about the process stream happens on production line. Lead time is 49.268,5 second and value added time is 409,96 second. Based on process activity mapping current state, there are activities that supported the waste motion to occurred in the production process. The next step is to find the root cause that makes waste motion exist using fishbone diagram. Based on fishbone diagram, the root cause that makes waste motion happen are man, method, and tool factors. 5 Why is used to find activities that cause waste motion. The root cause of all activities that cause waste motion will be reduced using 5S principle on production floor and make a storage tools. After that cycle time of activities that cause waste motion will be reduced or eliminated, the activities are looking for cutter, walking to take the work tool, looking for a cleaning tool and walking to put the cleaning tool.

Keyword: Lean Manufacturing, waste motion, 5S